

# Work Order ID 74850

**\*74850\***

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Wednesday, October 12, 2011 9:17:26 AM

Item ID: D3183-045 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bearing Assembly  
 Start Date: 10/12/2011 Start Qty: 100.00 **\*100\*** Cust Item ID:  
 Required Date: 10/19/2011 Req'd Qty: 100.00 **\*100\*** Customer:  
 Reference:

Approvals: Process Plan: mf Date: 11-10-12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3183	Rev C1								

100 Hardinge CNC LATHE SMALL 0.00  
**\*100\***  
 Hardinge Memo 0.00  
 Hardinge CNC Lathe Small Turn D3183-9 Cap as per Folio FA388 Debur

10/10/13

110 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control

10/10/13

120 QC8- Inspect parts - second check 0.00  
**\*120\***  
 QC Memo 0.00  
 Quality Control

11/10/13

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Packaging

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*74850\***

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 10/12/2011      **Start Qty:** 100.00

**\*100\***

**Cust Item ID:**

**Required Date:** 10/19/2011      **Req'd Qty:** 100.00

**\*100\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

### Tool ID

Tool #

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

mf  
11-10-12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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# Picklist Print

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Work Order ID: 74850

Parent Item: D3183-045

Parent Item Name: Bearing Assembly

Start Date: 10/12/2011

Required Date: 10/19/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP A04.02.18New issueKJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-5 Bearing		Manufactured	No			110	Each	42.0000	1	100			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST236		42							
				67529		1							
				73797		1							
				74542		40							
MDELRR1.000 Delrin Round Bar 1"		Purchased	No			130	f	32.1180	0.0333	3.5052632			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT055		32.118							
				117985		0.407							
				118257		18.002							
				118392		13.709							

9/5 11/10/17

B 74851

84x

10/10/13

3.488

W/O:		WORK ORDER CHANGES					
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Cap		<b>Part Number:</b>	<b>D3183-9</b>
<b>Inspection Dwg:</b> D3183	<b>Rev:</b> C1		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST



**X**

## First Article

11

## Prototype

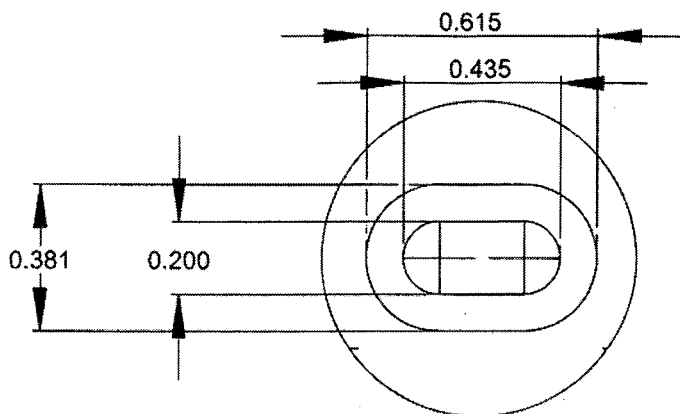
[illegible]

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/10/13	Date:	11/10/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3183-045)	KJ/RF	
B	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM	



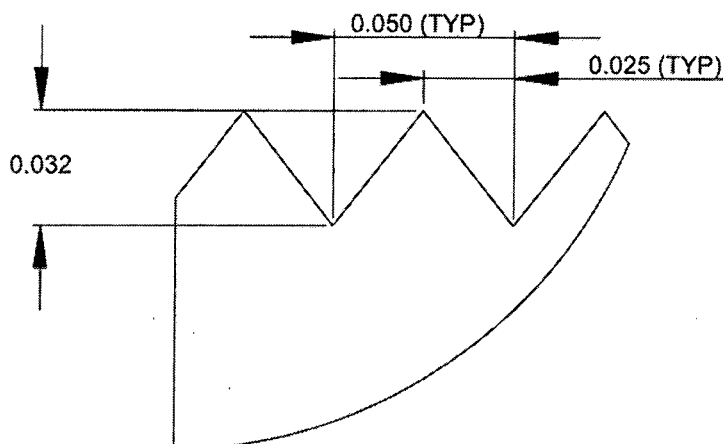
DESIGN #	DRAWN BY IP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3183</b>	REV. C SHEET 4 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1



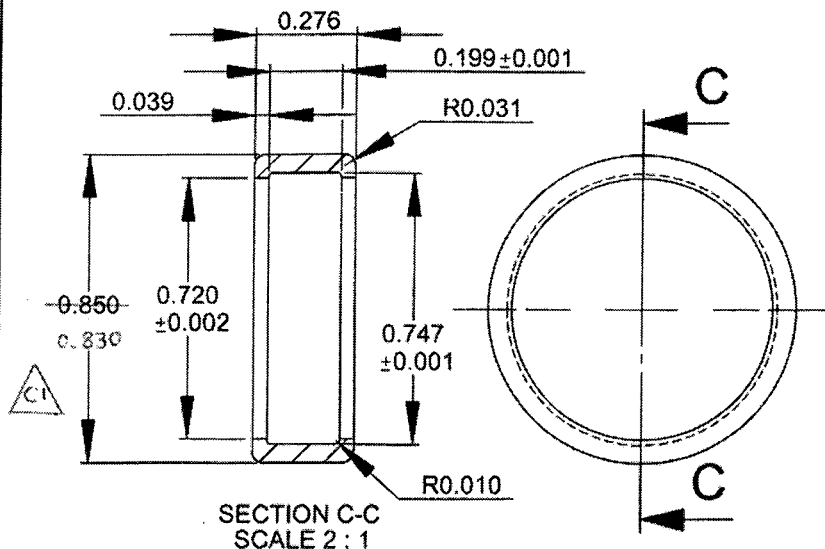
DETAIL A (2 : 1)

RELEASED  
04.03.01

DEO ATTACHED



DETAIL B (20 : 1)



**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP

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**Dart Aerospace Ltd**

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